



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D4131-3
Job Sheet 184884



Part No: D4131-3

Job Qty: 5 ea

Part Name: Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/17/18

Job Tracking No:

Due Date: 10/26/18

Created By: Shannon Hadley

Type: SOLD

Description:

Note: DWG REV C SHEETS 6,7 IPP Rev:A 10.10.06 new issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	5 pcs		10/26/18	0.00	0.41	Waterjet 1		SC 1840/18
120	QC	5 pcs		10/26/18	0.00	0.00	QC8		38
130	Brake NC	5 pcs		10/26/18	0.03	0.43	Brake NC 2		JD 9-89 DAS
140	QC	5 pcs		10/26/18	0.00	0.00	QC5		38
150	Packaging	5 pcs		10/26/18	0.00	0.00	Packaging3		78c 9-89
160	QC21-SA	5 Ea		10/26/18	0.00	0.00	QC21		DAS 21 9-89 NOV 13 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.8070 sf (.1614 ea)	100-Waterjet	5052628

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M304S18GA	1	149	0



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CANADA
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Container No: S119379



Part: D4131-3

Job No: 184884

Serial No/Batch: S119379

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/18/18

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Base	0.098Inches + 0.004 - 0.001	0.102 0.097	0,098	Diameter
2	Base	0.565Inches + 0.008 - 0.001	0.573 0.564	0,565	Diameter
3	Base	1.220Inches ± 0.030	1.250 1.190	1,225	
4	Base	1.380Inches ± 0.010	1.390 1.370	1,383	
5	Base	1.380Inches ± 0.030	1.410 1.350	1,382	
6	Base	2.750Inches ± 0.010	2.760 2.740	2,754	
7	Base	3.810Inches ± 0.010	3.820 3.800	3,813	
8	Base	0.530Inches ± 0.030	0.560 0.500	0,536	
9	Base	4.180Inches ± 0.030	4.210 4.150	4,182	
10	Base	6.100Inches ± 0.030	6.130 6.070	6,095	
11	Base	0.050Inches ± 0.010	0.060 0.040	0,046	

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D4131-3
Job Sheet 184687



Part No: D4131-3

Job Qty: 5 ea

Part Name: Base



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/16/18

Job Tracking No:

Due Date: 10/26/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 6,7 IPP Rev:A 10.10.06 new issue DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		10/26/18	0.00	0.00	Start Up Waterjet		
100	Waterjet - B4B	5 pcs		10/26/18	0.00	0.41	Waterjet1		
120	QC	5 pcs		10/26/18	0.00	0.00	QC8		
130	Brake NC	5 pcs		10/26/18	0.03	0.43	Brake NC 2		
140	QC	5 pcs		10/26/18	0.00	0.00	QC5		
150	Packaging	5 pcs		10/26/18	0.00	0.00	Packaging3		
160	QC21-SA	5 Ea		10/26/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.8070 sf (.1614 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S18GA	1	149	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Base	0.098Inches + 0.004 - 0.001	0.102 0.097	Diameter	
2	Base	0.565Inches + 0.008 - 0.001	0.573 0.564	Diameter	
3	Base	1.220Inches ± 0.030	1.250 1.190		
4	Base	1.380Inches ± 0.010	1.390 1.370		
5	Base	1.380Inches ± 0.030	1.410 1.350		
6	Base	2.750Inches ± 0.010	2.760 2.740		
7	Base	3.810Inches ± 0.010	3.820 3.800		

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

8	Base	0.530Inches ± 0.030	0.560 0.500
9	Base	4.180Inches ± 0.030	4.210 4.150
10	Base	6.100Inches ± 0.030	6.130 6.070
11	Base	0.050Inches ± 0.010	0.060 0.040

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								